Types 874-CL8* and -CL9**
LOCKING CABLE CONNECTORS

(U. S. Patent No. 2,548,457)

Remove cable jacket and insulation to expose braid and inner conductor to dimensions shown in Figure 1.

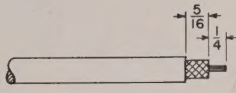

Figure 1.

Slip on cord guard (874-71 or 874-727; see Figure 2) using talc if necessary, locking nut (874-6177), coupling nut (874-6179), and ferrule (FEC-9). Slip inner transition piece (874-64) over inner cable conductor until the end touches cable insulation; then solder. Slide outer transition piece (874-63-2) over inner transition piece and under braid and jacket as far as possible. Install snap rings (874-81) in both grooves.

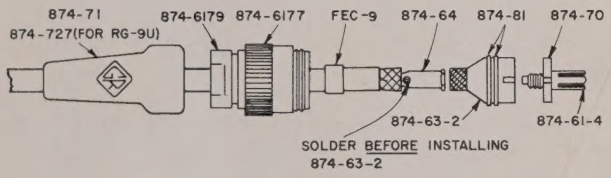

Figure 2.

Insert inner connector (874-61-4) in insulator (874-70) and thread into inner transition piece, holding the hex-shaped part with wrench.[1,2] CAUTION: Insulator will melt if inner connector and bead are screwed into inner transition piece before cable is soldered.

Slide outer transition piece up to insulator (874-70). Align keyways. Slip outer connector (874-60-3) over insulator (874-70) and outer transition piece so that keys engage keyways. With outer connector (874-60-3) seated on the first snap ring, tighten and arrange cable braid over small end of outer transition piece (874-62-3), cover with ferrule (FEC-9), and crimp in place. To crimp, use the Type 874-TO8 Crimping Tool or hold ferrule against a sturdy surface and pinch and push simultaneously with a

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*For use with Type RG-8/U Cable.
**For use with Types RG-9/U and RG-116/U Cable.

[1]The Type 874-TOK Tool Kit is recommended for assembly of all Type 874 Connectors. This kit consists of a Type 874-TO117 inner-connector wrench, a Type 874-TO115 outer-connector wrench, and a Type 874-TO116 coupling-nut wrench.

[2]To install inner connector and insulator in rigid line or inner transition piece using tools: insert inner connector into insulator and push assembly into the end of the inner-connector wrench, observing alignment of keys and keyways. Thread assembly into the rod or inner transition piece.

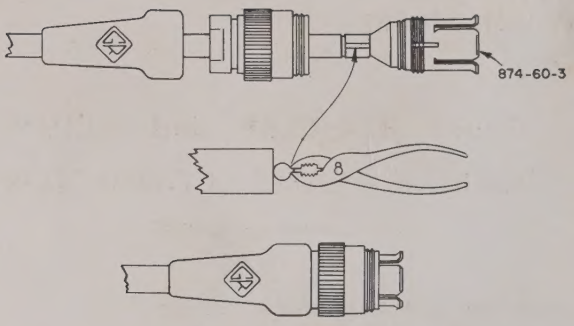

Figure 3.

pair of gas pliers as shown in Figure 3. The Crimping Tool is recommended for large-quantity operations or where the neatest crimp is desired. Use the 0.389-inch die with the Type 874-CL8 connector, and 0.411-inch die with the Type 874-CL9. To use the tool, disengage ratchet lock by squeezing the handles together, carefully position the ferrule in the appropriate die, and squeeze the handles together until the ratchet lock releases.

Be sure that the outer connector (874-60-3) is seated when the crimp is made.

Screw coupling nut (874-6179; see Figure 2) on outer connector until it bottoms firmly, using a wrench or the Type 874 Tools.[3]

Screw the locking nut (874-6177) onto the coupling nut (874-6179). Then stretch the rubber cord guard (874-71 or 874-727) over the coupling nut (874-6179) and seat lip in groove provided.

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[3]Clamp coupling-nut wrench on ring coupling nut, push outer-connector wrench onto outer connector, and hold while tightening coupling nut.

G E N E R A L R A D I O C O M P A N Y

WEST CONCORD, MASSACHUSETTS, USA

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